IS 11381 (1985): Extractor Cotter Pin [PGD 6: Earth, Metal And Wood Working Hand Tools]

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Indian Standard

SPECIFICATION FOR EXTRACTOR COTTER PIN

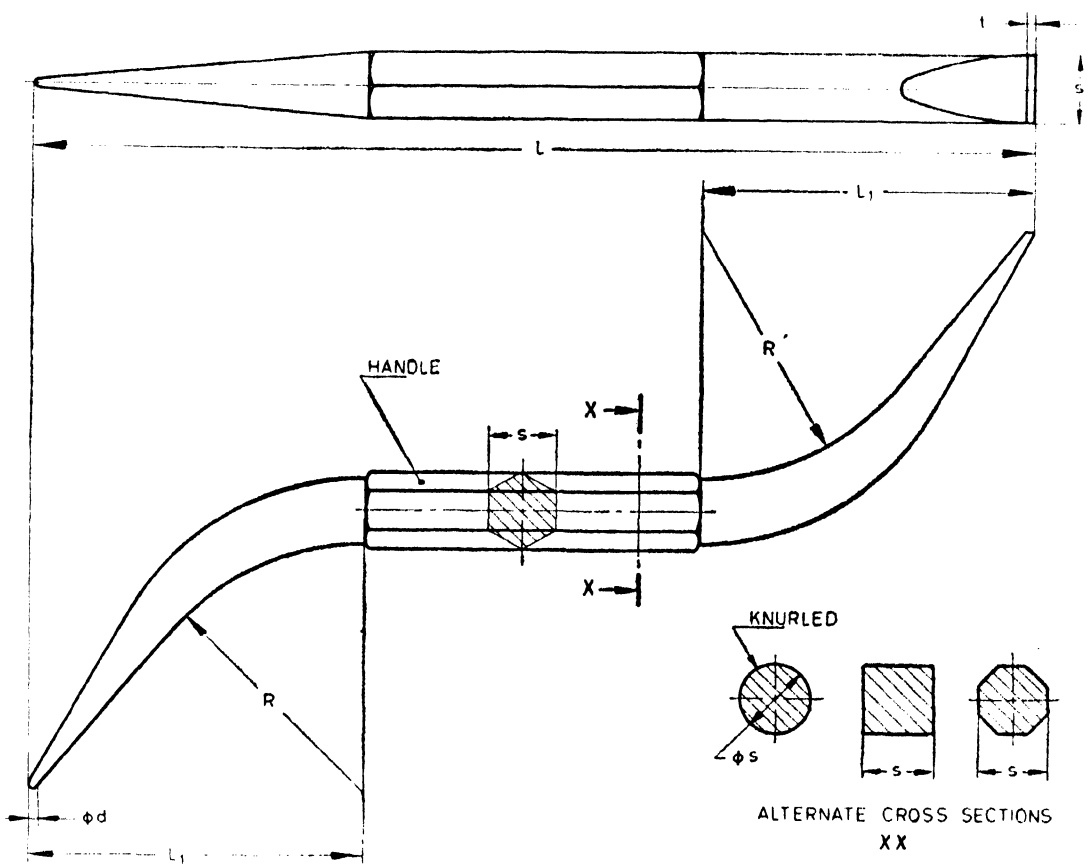
Hand Tools Sectional Committee, EDC 12; Metal Workers' Tool Subcommittee, EDC 12 : 2 [Ref : Doc : EDC 12 (4066)]

1. Scope — This standard covers the dimensions and other requirements of cotter pin extractor.

2. Dimensions — Shall be as given in Table 1.

TABLE 1 DIMENSIONS OF EXTRACTOR COTTER PIN

All dimensions in millimetres.



Length L		s		L_1 ±10	R Nom	Diameter of Pointed End, d Max	Thickness Chisel End, t Max
Min	Max	Min	Max				
150	250	8	10	50	38	0·8	1·2

3. Material — Shall be of suitable forged quality steel meeting the requirements laid down in 4.

Suitable example — Steel designation T80 with maximum sulphur and phosphorus contents of 0·05 percent each, of schedule VI of IS : 1570-1961 'Schedules for wrought steels for general engineering purposes'.

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4. Hardness — Both ends of the extractor shall be suitably hardened and tempered to achieve the hardness between 35 to 48 *HRC*.

5. Manufacture, Workmanship and Finish

5.1 Extractor shall be of square, hexagonal or octagonal in cross section having the same width across flats as specified in clause **2**. It may also be of circular cross-section which shall be knurled for easy grip. One end of the extractor shall be of circular cross-section, tapering from the nominal diameter of the handle to a pointed end. The opposite end shall be shaped and ground in the form of a chisel. The ends shall be curved in the opposite directions.

5.2 Extractors shall be smoothly finished and free from burrs, fins, cracks, flashes or any other imperfections that may impair serviceability.

5.3 These shall be plated, painted or treated to resist corrosion.

6. Sampling — Unless otherwise agreed to between the supplier and the purchaser, the procedure given in IS : 2500 (Part 1)-1973 'Sampling inspection tables : Part 1 Inspection by attributes and by count of defects (*first revision*)' shall be followed for sampling inspection. For various characteristics, the sampling plan as given in **6.1** and **6.2** shall be followed.

6.1 For inspection of dimensions, workmanship and finish, the sampling plan with inspection level II and acceptable quality level (AQL) 4 percent given in Table 1 and 2 of IS 2500 (Part 1)-1973 shall be followed.

6.2 For hardness test, the sampling plan with inspection level I and acceptable quality level (AQL) 2·5 percent given in Table 1 and 2 of IS : 2500 (Part 1)-1973 shall be followed.

7. Marking — The extractors shall be stamped with manufacturer's name, initials and/or recognized trade mark.

7.1 *ISI Certification Marking* — Details available with the Indian Standards Institution.

8. Packing — As per the best trade practices prevalent in the industry.

EXPLANATORY NOTE

Extractors cotter pin are used for removing the cotter pins; used as one of the locking devices. [For pins and cotters, IS : 549-1974 'Split pins (*second revision*)' and IS : 2638-1974 'Flat split cotters (*first revision*)' may be referred].

While formulating this specification, considerable assistance has been derived from Interim Federal Specification — GGG-F-C0926C (GSA-FSS) 'Extractor, cotter pin, Issued by Federal Supply Services, USA.

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TO
IS 11381 : 1985 SPECIFICATION FOR EXTRACTOR COTTER PIN

(*Page* 2, *clause* 6, *line* 2) — Substitute 'IS 2500 (Part 1) : 1992 Sampling inspection procedures : Part 1 Attribute sampling plans indexed by acceptable quality level (AQL) for lot-by-lot inspection (*second revision*)' *for* 'IS : 2500 (Part 1) - 1973 Sampling inspection tables : Part 1 Inspection by attributes and by count of defects (*first revision*)'.

(*Page* 2, *clauses* 6.1 and 6.2, *line* 2) — Substitute 'Tables I and II-A of IS 2500 (Part 1) : 1992' *for* 'Tables 1 and 2 of IS : 2500 (Part 1) - 1973'.

(PE 06)

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